

Date: Monday, 02/03/2009 11:23:43 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR SLUG
Job Number : 46165	
Estimate Number : 10162	
P.O. Number :	Part Number : D2587
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D2587 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 41433	Material :
Written By :	Due Date : 13/03/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 09.03.02</u>	
Comment : Est D 04.05.31 Step 2 changed KJ/JLM	
Est E 06.07.31 Waterjet EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6S040

6061-T6 .040 Sheet



Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.3360 sf(s)

6061T6 alum. sheet 0.040" thick

Batch: 109058*

ml 09 03 10

(20)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2587

Dwg Rev: A1Prog Rev: A1

2-Deburr if necessary

ml 09 03 10

(20)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 03 10



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



JOS-03-10 (20)



Comment: SECOND CHECK

counted.

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BF 09-03-11

(20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:23:43 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SLUG

Job Number: 46165

Part Number: D2587

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MD



Comment: INSPECT ALODINE

09-03-12

20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 30

9/3/12

20

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/13

20

mf
09-03-13

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

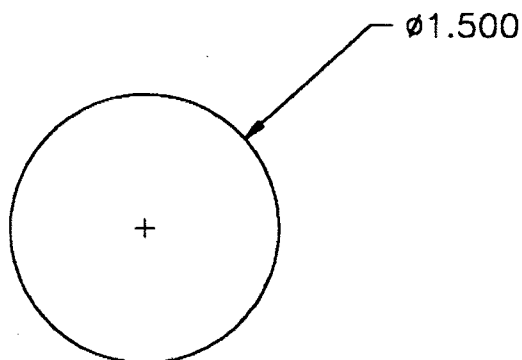
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED M.M.	APPROVED M.M.	D2587	SHEET 1 OF 1
DATE	TITLE		SCALE
96:07:11	DOOR SLUG		1:1
AI KJH 03.09.16		ADD 6061-T6 OPTION	

RELEASED
9607/23 B.W.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 446165

OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 
MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE